

Date: Monday, 1/30/2006 8:08:37 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CHAFING SHIELD
Job Number	: 25658		
Estimate Number	: 10840		
P.O. Number	: N/A	Part Number	: D31891
This Issue	: 1/30/2006 S.O. No. : N/A	Drawing Number	: D3189 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 24860	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 2/15/2006 Qty: 12 Um: Each
Checked & Approved By	: <u>06.01.30</u>		
Comment	: Est. B 05.08.22 No longer made in-house KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S25GA	304/316 .020" Sheet
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Comment: Qty.: 0.3360 sf(s)/Unit Total : 4.0320 sf(s)  
 304/316 SS .020" Sheet  
 (M304S25GA)  
 Batch: 719704

2.0	SHEAR	SHEAR
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Comment: SHEAR  
 Cut to size as per Dwg D3189

SAD 06.03.23 (12)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr & Grind Rads as per Dwg D3189

SAD 06.03.23 (12)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06.03.23

5.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O.  
 Roll D3189-1 as per Dwg D2646  
 Possible Supplier: Metec/Mast.

Roll in house.

SAD 06/04/06 12

12  
PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-23	5	Rolling done at Dart.  Permanent change				108 95412	06-03-23

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CHAFING SHIELD

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Part Number: D31891

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

N/A

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3189

06/04/10 (12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST134

For

AR 06/04/10 (12)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/11 (12)

Job Completion



U 06/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

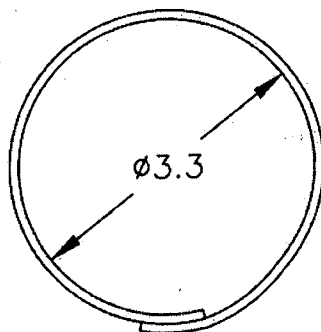
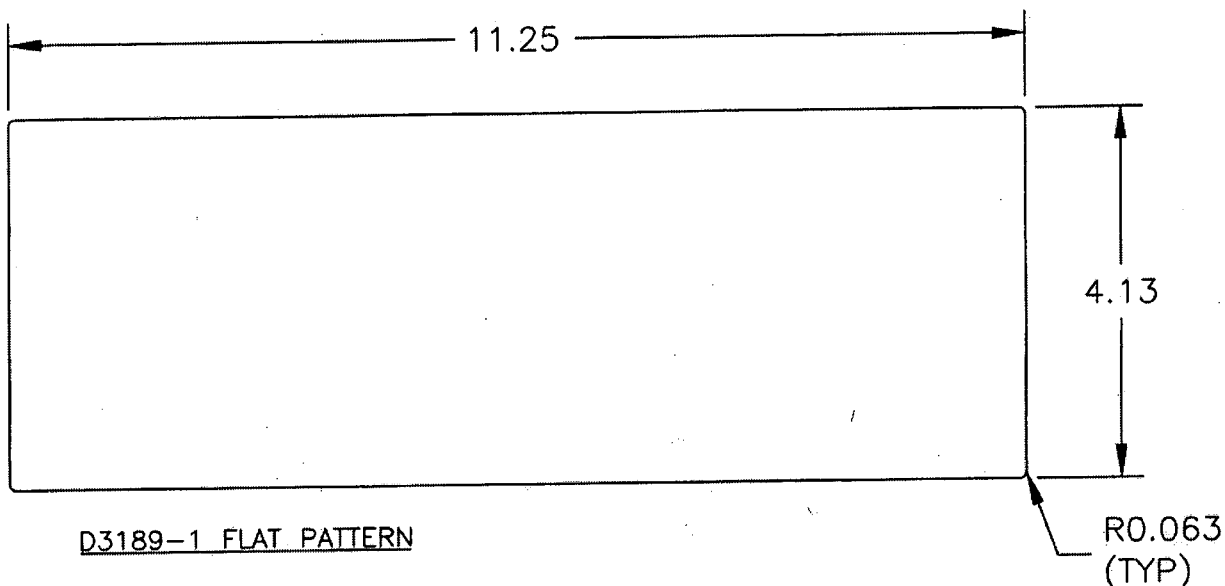
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3189	REV. A SHEET 1 OF 1
DATE 03.05.08		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	

RELEASED  
03.05.08



D3189-1 ROLLING DETAIL  
NOT TO SCALE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25658

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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